

Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

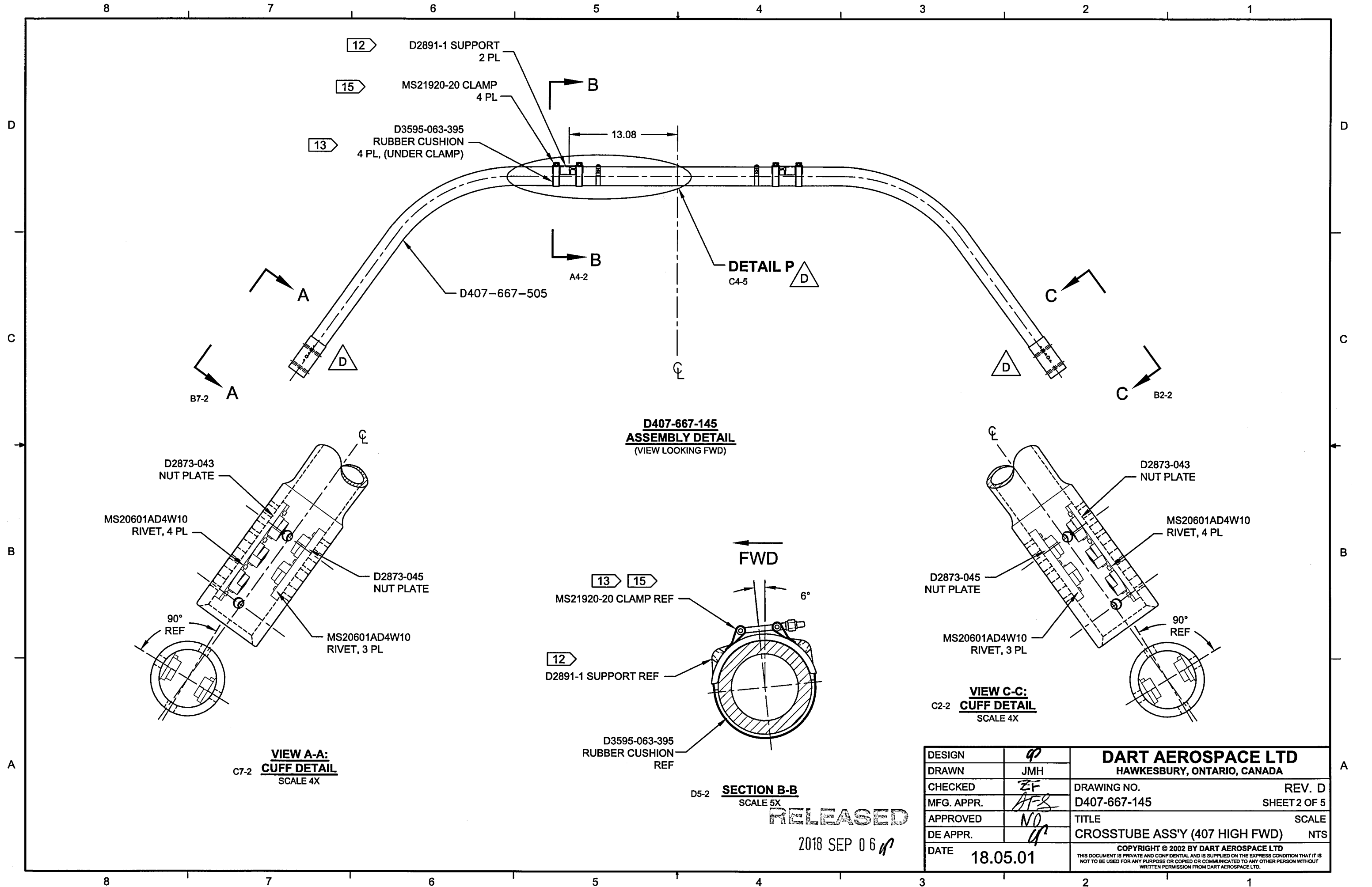
GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 17.8 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- TO INSTALL D2891-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**
- MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS.

RELEASED

2018 SEP 06
2018-797

D	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO C-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO C-2.	JMH	18.05.01
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D407-667-145	SHEET 1 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D407-667-145
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

VIEW A-A:
CUFF DETAIL
SCALE 4X

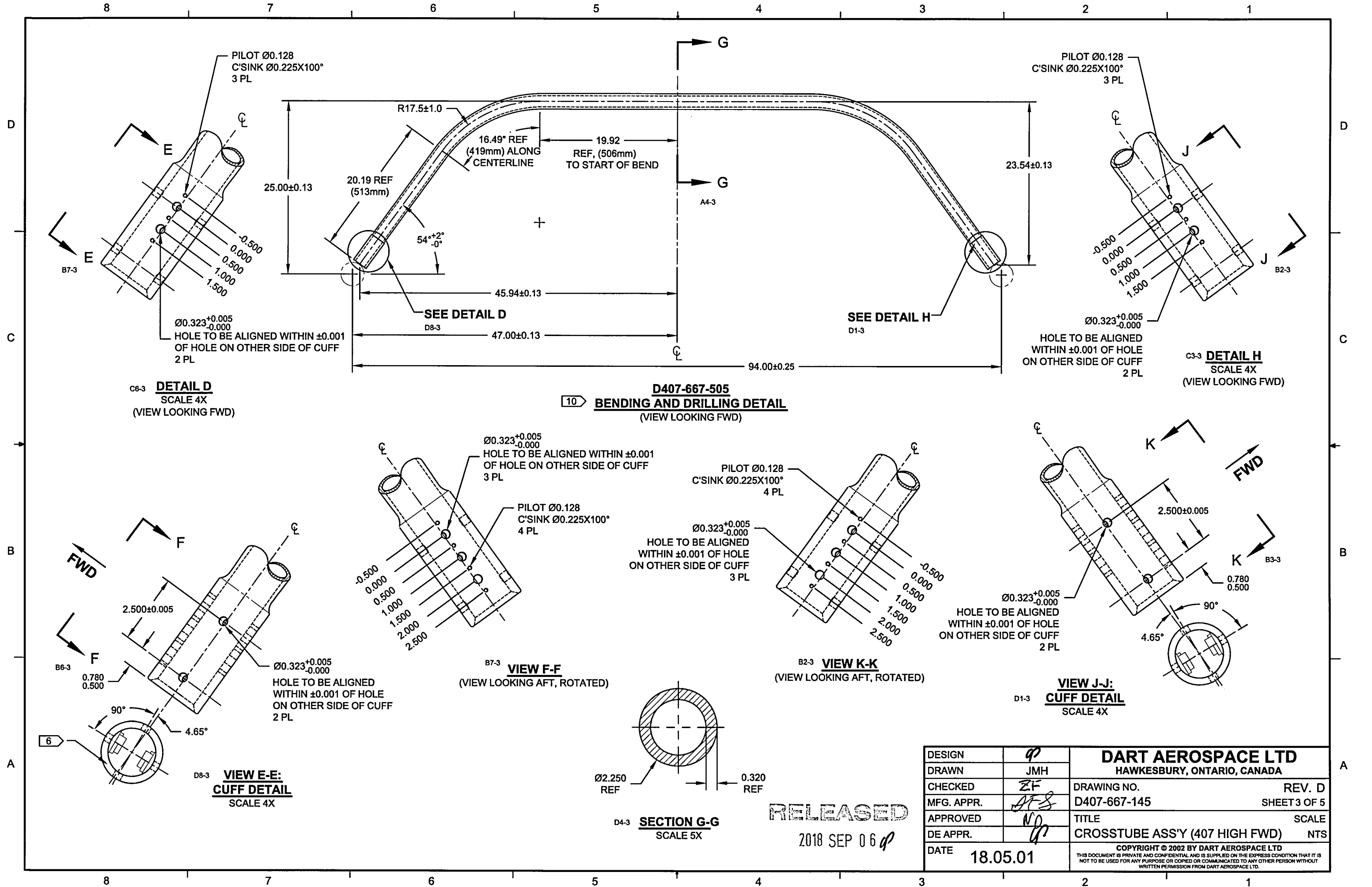
SECTION B-B
SCALE 5X

VIEW C-C:
CUFF DETAIL
SCALE 4X

DESIGN	407	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFS	D407-667-145	SHEET 2 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	407	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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2018 SEP 06



D407-667-505
BENDING AND DRILLING DETAIL
 (VIEW LOOKING FWD)

DETAIL D
 SCALE 4X
 (VIEW LOOKING FWD)

DETAIL H
 SCALE 4X
 (VIEW LOOKING FWD)

VIEW E-E:
CUFF DETAIL
 SCALE 4X

VIEW F-F
 (VIEW LOOKING AFT, ROTATED)

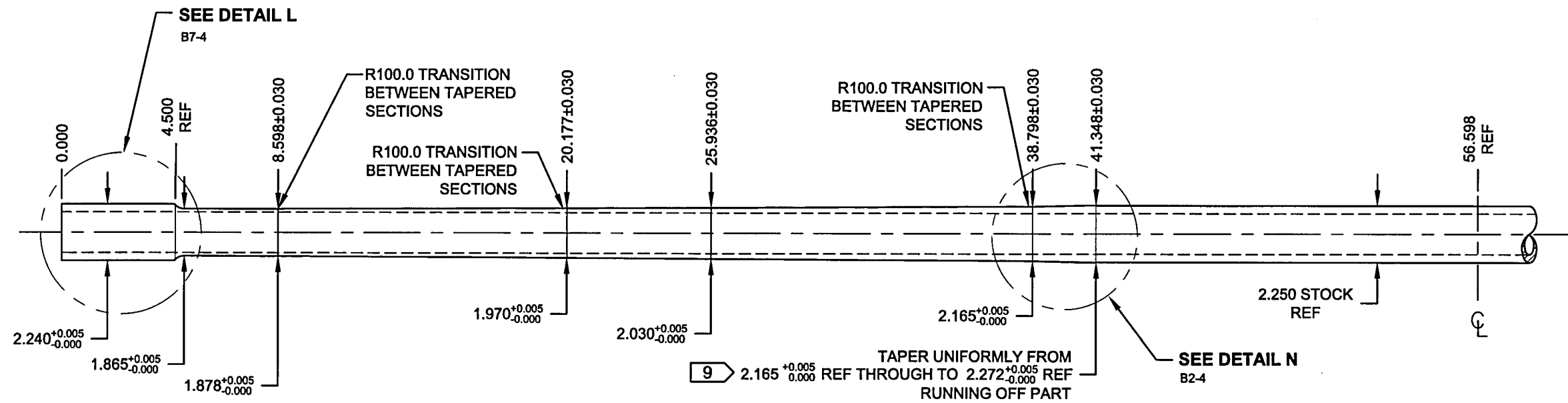
VIEW K-K
 (VIEW LOOKING AFT, ROTATED)

VIEW J-J:
CUFF DETAIL
 SCALE 4X

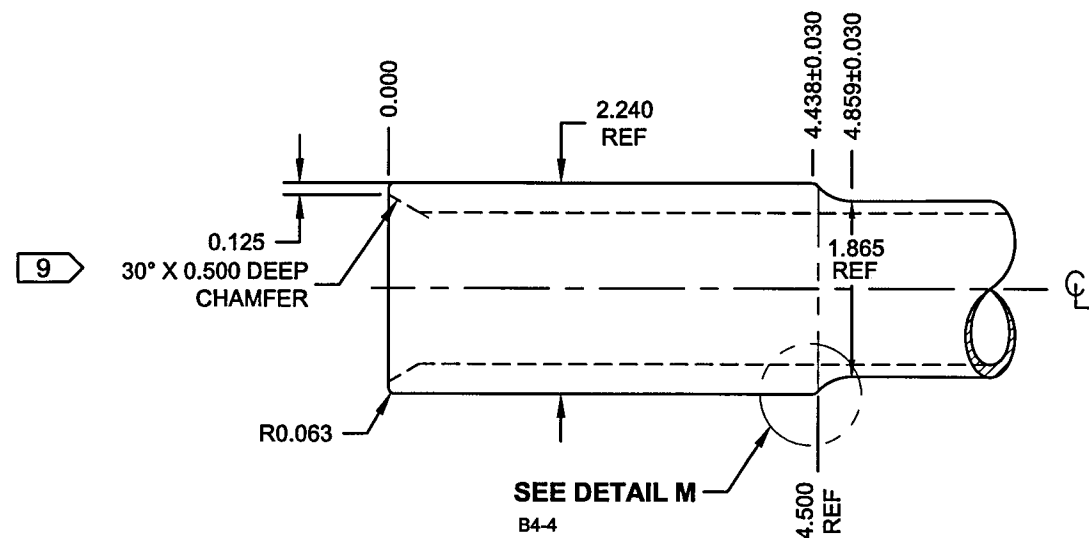
SECTION G-G
 SCALE 5X

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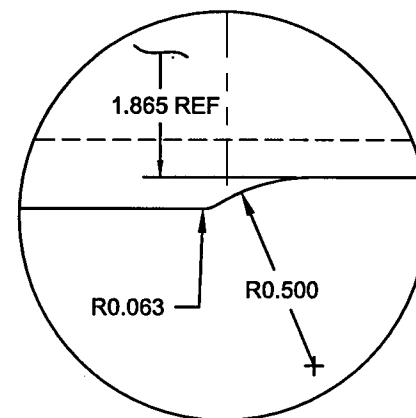
DESIGN	qp	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	DFS	D407-667-145	SHEET 3 OF 5
APPROVED	NP	TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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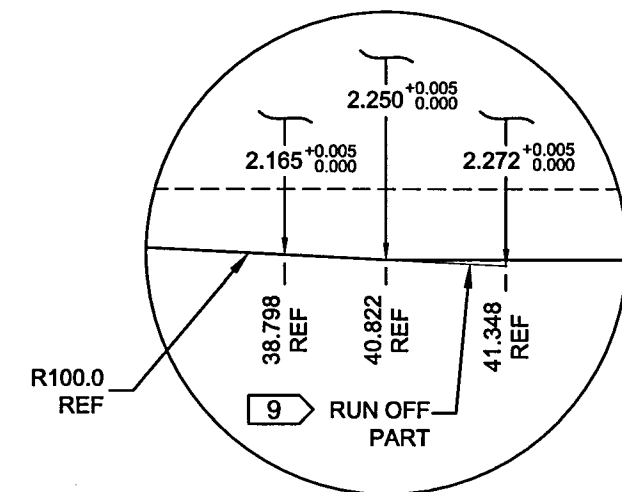
TURNING DETAIL



DETAIL L:
D7-4 **CROSSTUBE CUFF**
NOT TO SCALE



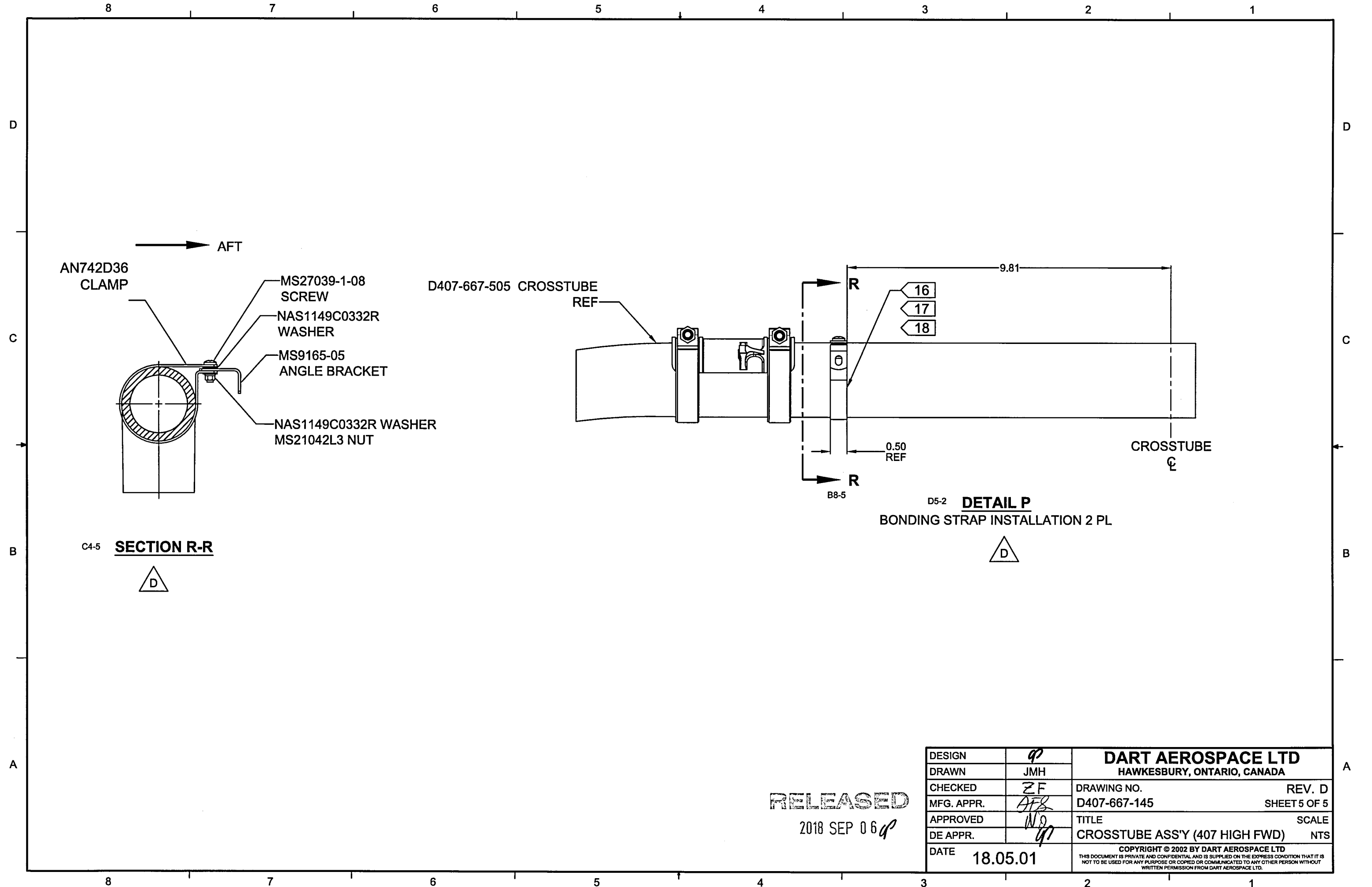
DETAIL M:
B6-4 **CUFF TRANSITION**
NOT TO SCALE



DETAIL N:
C3-4 **TAPER RUN-OFF**
NOT TO SCALE

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2018 SEP 06

DESIGN	97	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFS	D407-667-145	SHEET 4 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D407-667-145	SHEET 5 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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